

What is claimed is:

1. A resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a
5 concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material,
- 10 wherein a position of a burr to be generated by a flow of said resin material into a gap between a combined molding die and a core in a process of molding of said resin piston for a master cylinder by injection molding is a position but an inner wall surface of said communicating hole.
- 15 2. The resin piston for a master cylinder as in claim 1, wherein a groove making said inner wall surface nearby a part, with which said communicating hole communicates, of said through-hole flat in a direction in which said stopper pin is inserted.
- 20 3. The resin piston for a master cylinder as in claim 2, wherein a width of said groove is narrower than that of said through-hole and wider than a diameter of said stopper pin.
- 25 4. The resin piston for a master cylinder as in claim 1, wherein said through-hole includes a projecting part for preventing said stopper pin from being touched to the inner wall surface nearby a part with which said communicating hole communicates.
5. A resin piston for a master cylinder including a through-hole through which a stopper pin being a component

of a valve mechanism of said master cylinder is inserted, a concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston
5 for a master cylinder being molded by injection of a resin material,

wherein:

said through-hole is molded with a core for through-hole molding;

10 said concavity and said communicating hole are molded with a core for molding a concavity;

a part where said through-hole communicates with said communicating hole is molded in a state such that an end of said core for molding a concavity is impacted in an
15 impact hole formed on said core for through-hole molding.

6. The resin piston for a master cylinder as in claim 5, wherein:

said resin piston for a master cylinder is molded with a die formed by a combination of a first die and a second die,
20 the first die including a first core, the second die including a second core; and

said core for through-hole molding is constructed by a combination of the first core and the second core, whereby said impact hole is formed.

25 7. The resin piston for a master cylinder as in claim 5, wherein a groove making said inner wall surface nearby a part, with which said communicating hole communicates, of said through-hole flat in a direction in which said stopper pin is inserted.

8. The resin piston for a master cylinder as in claim 7, wherein a width of said groove is narrower than that of said through-hole and wider than a diameter of said stopper pin.

9. The resin piston for a master cylinder as in claim 5,
5 wherein said through-hole includes a projecting part for preventing said stopper pin from being touched to the inner wall surface nearby a part with which said communicating hole communicates.

10. A resin piston for a master cylinder including a
through-hole through which a stopper pin being a component
of a valve mechanism of said master cylinder is inserted, a
concavity in which said valve mechanism is fixed by being
inserted therein, and a communicating hole communicating
with said through-hole from said concavity, said resin piston
15 for a master cylinder being molded by injection of a resin
material,

wherein:

said through-hole is molded with a core for
through-hole molding;

20 said concavity and said communicating hole are
molded with a core for molding a concavity;

an inner wall surface of said through-hole nearby a
part where said communicating hole communicates with said
through-hole is in a shape of a flat surface.

25 11. A master cylinder equipped with a resin piston for
said master cylinder, said resin piston for a master cylinder
including a through-hole through which a stopper pin being
a component of a valve mechanism of said master cylinder is
inserted, a concavity in which said valve mechanism is fixed

by being inserted therein, and a communicating hole
communicating with said through-hole from said concavity,
said resin piston for a master cylinder being molded by
injection of a resin material, wherein a position of a burr to
5 be generated by a flow of said resin material into a gap
between a combined molding die and a core in a process of
molding of said resin piston for a master cylinder by injection
molding is a position but an inner wall surface of said
communicating hole.

10 12. A master cylinder equipped with a resin piston for
said master cylinder, said resin piston for a master cylinder
including a through-hole through which a stopper pin being
a component of a valve mechanism of said master cylinder is
inserted, a concavity in which said valve mechanism is fixed
15 by being inserted therein, and a communicating hole
communicating with said through-hole from said concavity,
said resin piston for a master cylinder being molded by
injection of a resin material, wherein: said through-hole is
molded with a core for through-hole molding; said concavity
20 and said communicating hole are molded with a core for
molding a concavity; a part where said through-hole
communicates with said communicating hole is molded in a
state such that an end of said core for molding a concavity is
impacted in an impact hole formed on said core for
25 through-hole molding.

13. A master cylinder equipped with a resin piston for said
master cylinder, said resin piston for a master cylinder including a
through-hole through which a stopper pin being a component of a
valve mechanism of said master cylinder is inserted, a concavity in

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- which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material, wherein: said through-hole is molded with
5 a core for through-hole molding; said concavity and said communicating hole are molded with a core for molding a concavity; an inner wall surface of said through-hole nearby a part where said communicating hole communicates with said through-hole is in a shape of a flat surface.
- 10 14. A die for molding a resin piston for a master cylinder, said die molding a resin piston for a master cylinder, said resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve
15 mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material, said die comprising a core for through-hole molding for molding said through-hole and a core for molding a concavity
20 for molding said concavity and said communicating hole, wherein a part where said through-hole communicates with said communicating hole is constructed such that the part is molded in a state in which an end of said core for molding a concavity is impacted in an impact hole formed on said core
25 for through-hole molding.

15. A manufacturing method of a resin piston for a master cylinder for manufacturing a resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master

cylinder is inserted, a concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder

- 5 being molded by injection of a resin material, said manufacturing method comprising the steps of:

molding said through-hole with a core for through-hole molding;

- molding said concavity and said communicating hole
10 with a core for molding a concavity; and

molding a part where said through-hole communicates with said communicating hole in a state such that an end of said core for molding a concavity is impacted in an impact hole formed on said core for through-hole molding.